

March 11, 2016 10:04:18 AM

Item ID: D350-567-113

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Replacement Exterior Super-sized Window

Stop ***NS2***

Start Date: 3/11/2016 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 3/14/2016 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals:

Process Plan:

Date: 20160311 Tooling:

Date:

Run Start *NR1*

QC:

Date: _____ **SPC (Y/N):** _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D350-567	E								
100	Document Control	0.00	DAS 6 9-89	Label		DAS 27 9-89			MW MAR 14 2016
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD350-567-113		CHG003						MAR 14 2016
110	Packaging	0.00							
110	Packaging	0.00				DAS 6 9-89			
Packaging	Memo								
Packaging	Pick Packing Kit								
	ENSURE DT 8439 TEMPLATE IS INCLUDED								MAR 14 2016
120	QC4- 100% Inspect kits for completeness	0.00							
120	QC	0.00							
Quality Control	Memo								
						DAS 27 9-89			MAR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Work Order ID 142648

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Item ID: D350-567-113

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N900040100Setup Start ***NS1***

Revision ID:

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Stop ***NS2***

Start Date: 3/11/2016 Start Qty: 1.00

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Cust Item ID:

Required Date: 3/14/2016 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-567-113 Location:FG032								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

BAS
27
9-89

MAR 14 2016

MAR 14 2016

MAR 14 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 142648

142648

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 3/11/2016**Required Date:** 3/14/2016**Start Qty: 1.00**

Required Qty: 1.00

Comments:

IPP Rev:A 04-08-24 New Issue JLM

IPP Rev:B 08-10-07 as per revD DD verified by:

IPP REV:C

13.10.15 AS PER IIN REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8439		Manufactured	No				Each	0.0000		1			
DT8439									**				DAS 28 9-89
TEMPLATE													
D2463		Manufactured	No			110	f	527.1991	7.166	7.543158			DAS 28 9-89
D2463									**				DAS 28 9-89
1/2" Seal (\$Per Foot)													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST409		500							
					140013	500							
				ST638		27.19906833							
					125469	27.1990683							
1x (D2463-0860 as per dwg) CUT TO 86.00"													
D3290-041		Manufactured	No			110	Each	5.0000		1			
D3290-041									**				DAS 28 9-89
Replacement Exterior Window For -111													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST433		5							
					130869	3							
					136402	2							

Picklist Print

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Work Order ID: 142648

142648

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 3/11/2016

Required Date: 3/14/2016

Start Qty: 1.00

Required Qty: 1.00

2600-6

Purchased No

110 Each

172.0000

12

12

2600-6

Camlock Stud

**

DAS

DAS

6

28

9-89

9-89

Location

Loc Qty

Loc Code

Sr569

48

M133064

48

ST578

74

M132767

24

M133483

50

ST580

50

M133932

50

2600-LW

Purchased No

110 Each

274.0000

12

12

2600-LW

Washer, Camlock Retaining

**

DAS

DAS

6

28

9-89

9-89

Location

Loc Qty

Loc Code

ST569

124

m131959

124

ST580

150

m134370

150

212-12

Purchased No

110 Each

164.0000

12

12

212-12

Receptacles

**

DAS

DAS

6

28

9-89

9-89

Location

Loc Qty

Loc Code

ST568

64

M133064

14

M133363

50

ST577

100

M133932

50

M134370

50

DAS

27

9-89

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 142648

142648

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 3/11/2016

Required Date: 3/14/2016

Start Qty: 1.00

Required Qty: 1.00

AN526C832R9

Purchased

No

110

Each

541.0000

21

21

DAS

6

9-89

DAS

28

9-89

AN526C832R9

Screw

Location

Loc Qty

Loc Code

ST327

341

M132823

66

M133932

150

M134063

125

ST328

200

M134376

200

DAS
27
9-89

NAS1149DN832J

Purchased

No

110

Each

2,123.000

42

42

DAS

6

9-89

DAS

28

9-89

NAS1149DN832J

Washer

Location

Loc Qty

Loc Code

CA

84

M129499

84

ST260a

1500

M134180

1500

ST263

539

M131697

539

MAR 14 2016

DAS
27
9-89

Picklist Print

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Work Order ID: 142648

142648

Parent Item: D350-567-113

D350-567-113

Parent Item Name: Replacement Exterior Super-sized Window

Start Date: 3/11/2016

Required Date: 3/14/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

110

Each

1,645.000

21

21

MS21042L08

Nut

DAS
27
9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

GA

161

m133134

3

m134063

158

OVER007

500

m134063

500

ST303

483

m133922

483

ST308

400

m134376

400

DAS
6
28
9-89

MS20426AD3-5

Purchased

No

110

Each

4,817.000

24

24

MS20426AD3-5

Rivet

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

4144

4533

4144

ST312

673

4444

673

DAS
6
28
9-89

FG-778150-550-ROI

Purchased

No

110

sf

576.1463

18

24

***FG-778150-550-ROI ***

7781 9oz Glass 50x125yd

DAS
27
9-89

Location

Loc Qty

Loc Code

CA2

576.1463415

M127701

576.146342

DAS
6
28
9-89
MAR 14 2016

2sq yards

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Shop Packet Print

Work Order ID 142648

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142648

Page 1

Item ID: D350-567-113

Accept

Revision ID:

N900040100Setup Start ***NS1***

Item Name: Replacement Exterior Super-sized Window

Stop ***NS2***

Start Date: 3/11/2016 Start Qty: 1.00

1

Required Date: 3/14/2016 Req'd Qty: 1.00

1

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan: SH Date: 20160311 Tooling: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN-D350-567

E

100

Document Control

DOCUMENT CONTROL

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

Photocopy bluefile & type labels per PPPD350-567-113

CHG003

MJS MAR 14 2016

110

110

Packaging

Packaging

0.00

Memo

0.00

Pick Packing Kit

ENSURE DT 8439 TEMPLATE IS INCLUDED

OAS
E
9-50

MAR 14 2016

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		(1)			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		(1)			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECERTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A ✓	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET